

Date: Tuesday, 7/17/2007 2:01:29 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 84 BRACKET  
 Job Number : 33599  
 Estimate Number : 11035  
 P.O. Number :  
 This Issue : 7/17/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D28032  
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D2803 REV B  
 Previous Run : 29404 Project Number : N/A  
 Material : B  
 Due Date : 8/3/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : 07.07.17  
 Comment : Est. A 00.11.06 New Issue EC  
 Est Rev:B Blanks now cut on Waterjet 06-06-14 JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
-----	--------------------	--------------------------



Comment: Qty.: 2.0125 f(s)/Unit Total: 20.1254 f(s)  
 6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch:

M105145 SAD 07/08/03

~~M102508 SAD 07/08/03~~

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Template DT8533

Dwg Rev: NAProg Rev: NA

2-Deburr if necessary

SAD 07/08/03  
~~SAD 07/08/03~~

10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

SAD 07/08/13

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07-08-14

10

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAD 07/08/14 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 7/17/2007 2:01:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 33599

Part Number: D28032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

36 07-08-14

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

36 07-08-10

(10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR/m.d

07-8-15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/08/15 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-15

Job Completion



07/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 33599
<b>Description:</b> Bracket		<b>Part Number:</b> D2803-2
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	758				
1.420	+/-0.001	1.420				
Ø0.191	+0.005/-0.000	.1915				
Ø0.507	+0.000/-0.001	.507				
Ø0.507 x 0.250	+0.000/-0.001	507 x .251				
12.411	+/-0.010	12.411				
6.933	+/-0.010	6.933				
0.250	+/-0.010	.251				
0.875	+0.000/-0.005	.874				
0.250	+0.000/-0.005	.248				
0.125	+/-0.010	.125				
0.125	+/-0.010	.125				
0.500	+/-0.010	.500				
0.125	+/-0.010	.125				
0.188	+/-0.010	.186				
0.562	+/-0.010	.564				
0.125	+/-0.010	.125				

<b>Measured by:</b> JF	<b>Audited by:</b> gml	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/08/13	<b>Date:</b> 07/08/14	<b>Date:</b>	N/A

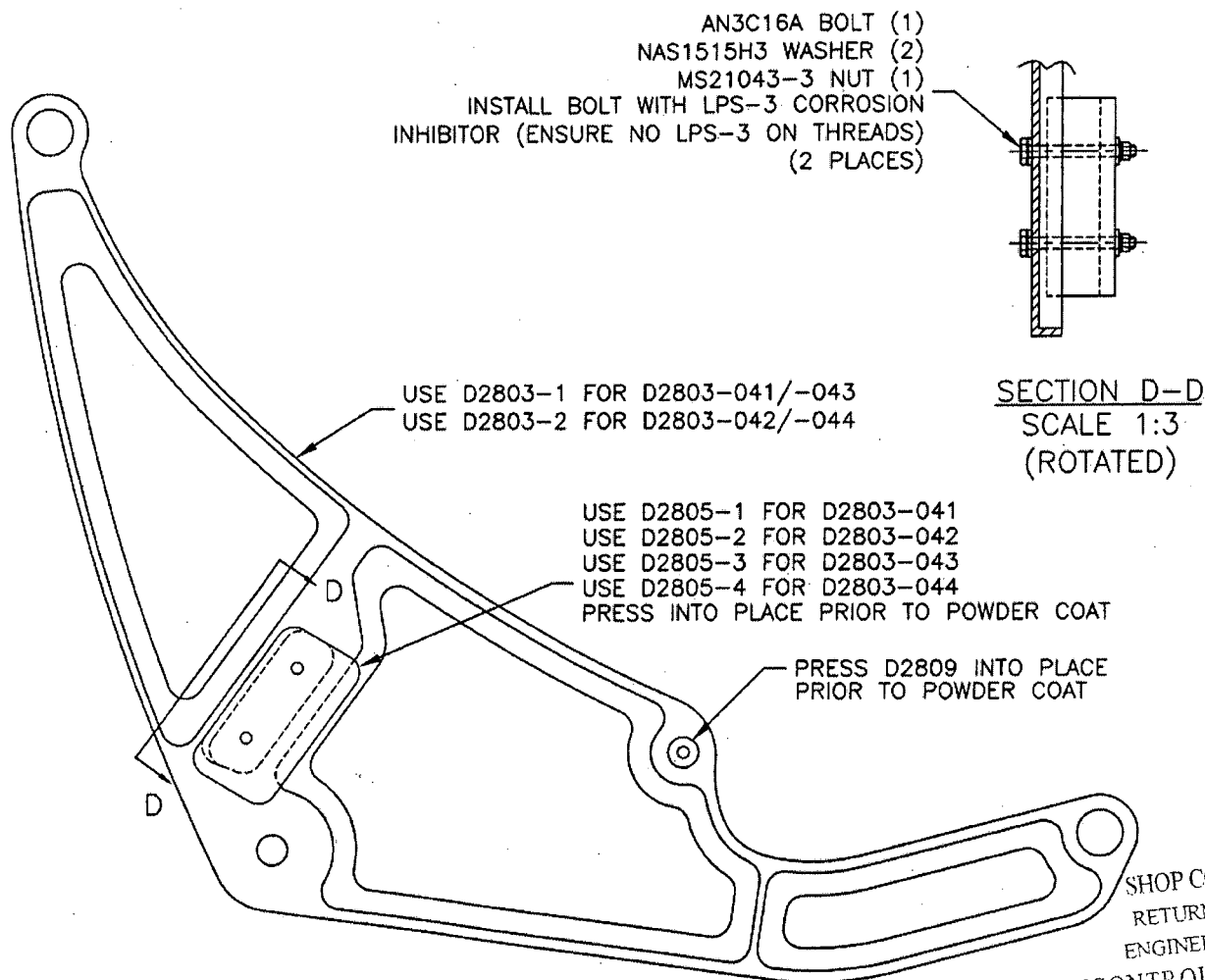
  

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	





DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

RELEASED 33599

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.